

# Work Order ID 86230

June-25-12 10:30:58 AM

**\*86230\***

Page 1

Item ID: D3535-15 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 25/06/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 10/07/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/06/25 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B					(10)			
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
304 .040									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

B12-6-26

B17-6-20

Sidbelet

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86230

**\*86230\***

Page 2

June-25-12 10:30:58 AM

Item ID: D3535-15

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearshoe

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-15								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:40								
	FINISH TIME: 8:10								

(10)

SB 12/07/04

410

5 12/07/04

mk

10X

12/07/04

M121279

3200F

8:10

W/O:		WORK ORDER CHANGES					
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**\*86230\***

June-25-12 10:30:58 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 25/06/2012      **Start Qty:** 8.00

**\*8\***

**Required Date:** 10/07/2012      **Req'd Qty:** 8.00

**\*8\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**

### Process Plan:

Date:

**Tooling:**

Date:

Stop \*NR2\*

**QC:**

Date:

**SPC (Y/N):**

**Date:**

**Insp.  
Stamp**

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location:

0.00

\*170\*

## Packaging

## Memo

0.00

### Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

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**NOTE:** Date & initial all entries

# Picklist Print

June-25-12 10:31:03 AM

Page 1

Work Order ID: 86230

\*86230\*

Parent Item: D3535-15

\*D3535-15\*

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	352.7693	1.0205	8.593684	11.		

\*M304S20GA\*

\*\*

B12-6-20

304/316 .040 Sheet

Location	Loc Qty	Loc Code
001	52.4914105	
121192	52.4914105	
MAT020	300.277922	
117933	27.3442	
118400	5.3723	
118964	23.2	
119346	24.8	
121380	49.761422	
121901	169.8	

121901

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 86230
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.890	2		V B&2	
2.000	+/-0.010	2.000	2		V	
5.650	+/-0.010	5.650	✓		T B&1	
9.150	+/-0.010	9.150	✓		T	
14.400	+/-0.010	14.400	✓		T	
19.650	+/-0.010	19.650	✓		T	
24.900	+/-0.010	24.900	✓		T	
30.150	+/-0.010	30.150	✓		T	
33.650	+/-0.010	33.650	✓		T	
35.650	+/-0.010	35.650	✓		T	
39.150	+/-0.010	39.150	✓		T	
Ø0.188	+0.005/-0.001	.190	✓		V	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
5.00	+/-0.030	5.00	✓		T	
0.300	+/-0.010	.304	✓		V	
0.300	+/-0.010	.301	✓		V	
0.038	+/-0.010	.037	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-6-06	Date: 12/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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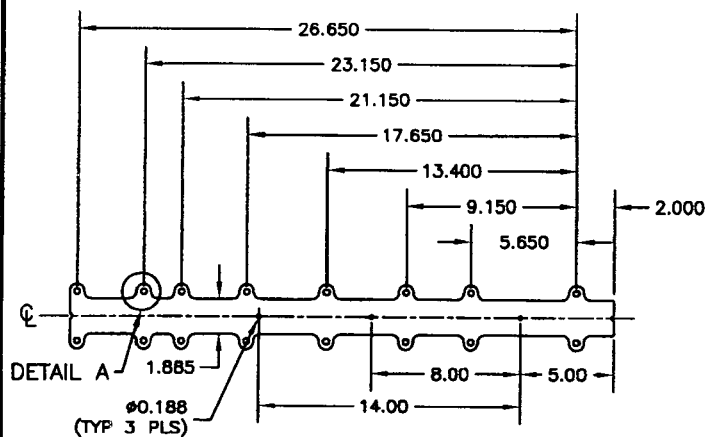
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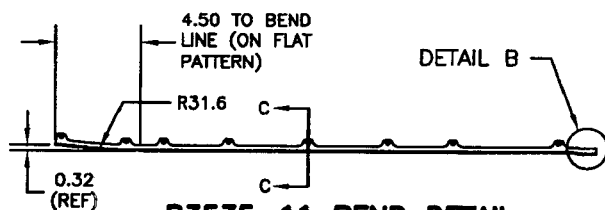
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07.04.17

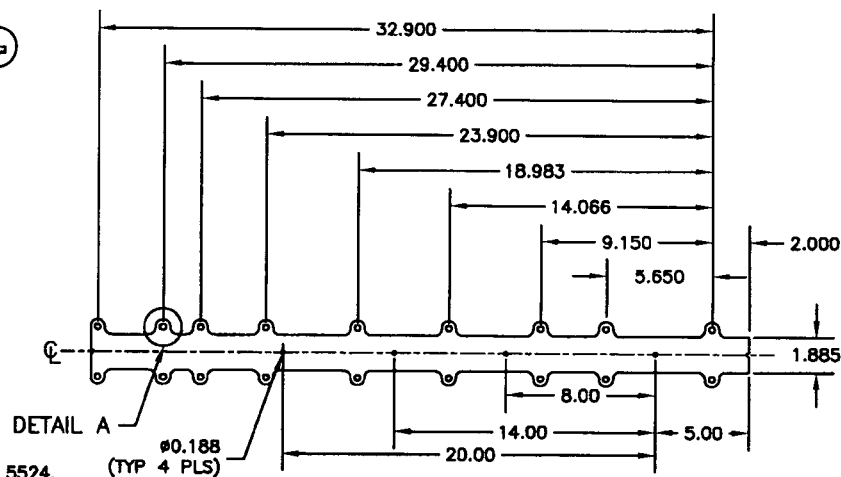
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86230 MLJ  
12/06/30



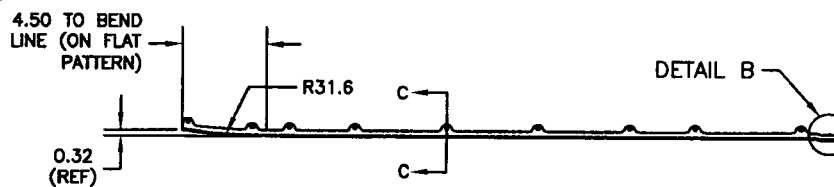
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 013 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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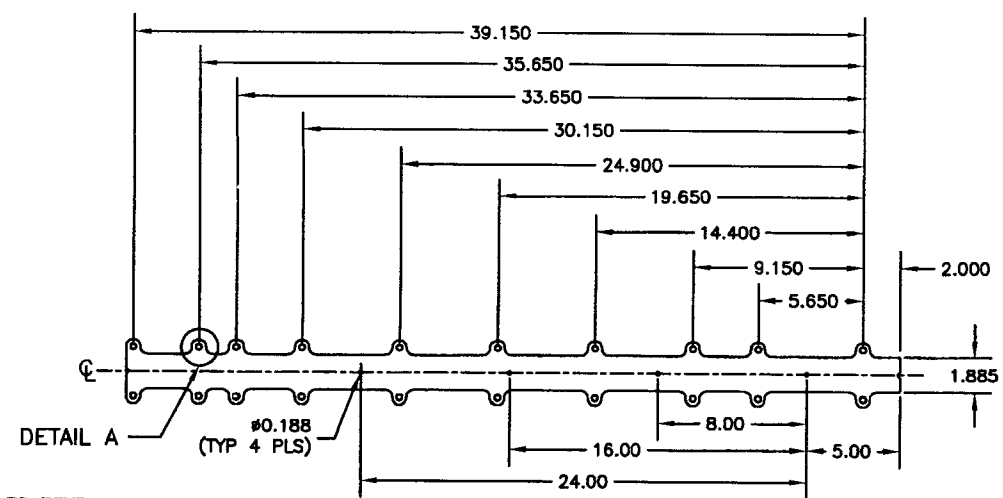
**NOTE:** Date & initial all entries

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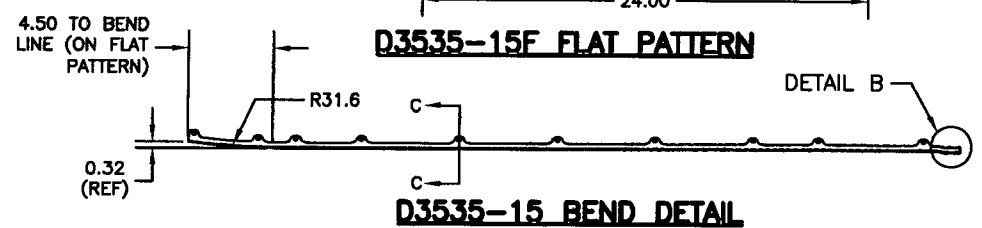


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07.04.24

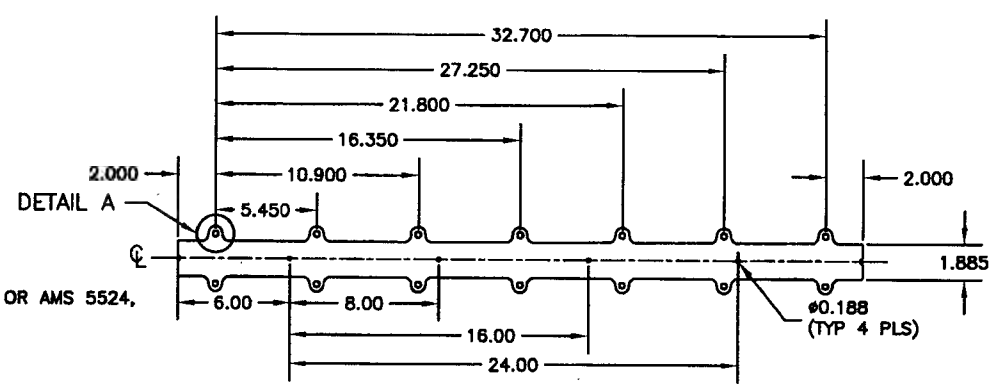
DESIGN <b>CB</b>	DRAWN BY <b>CH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 2 OF 7
		SCALE 1:10



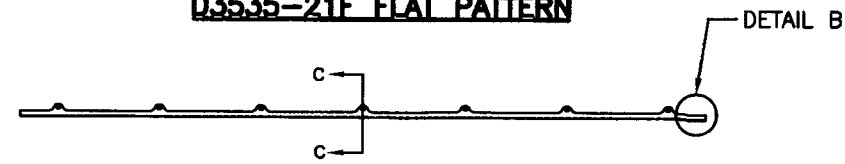
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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W/O:		WORK ORDER CHANGES					
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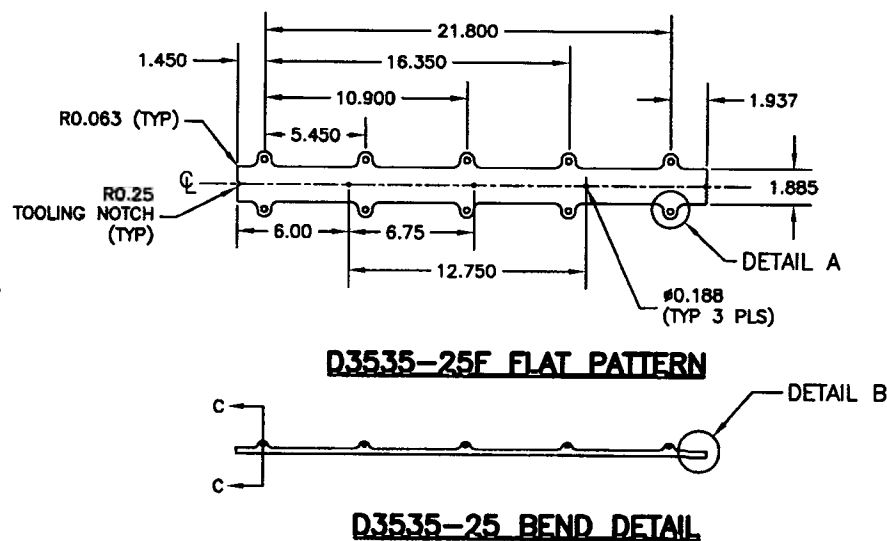
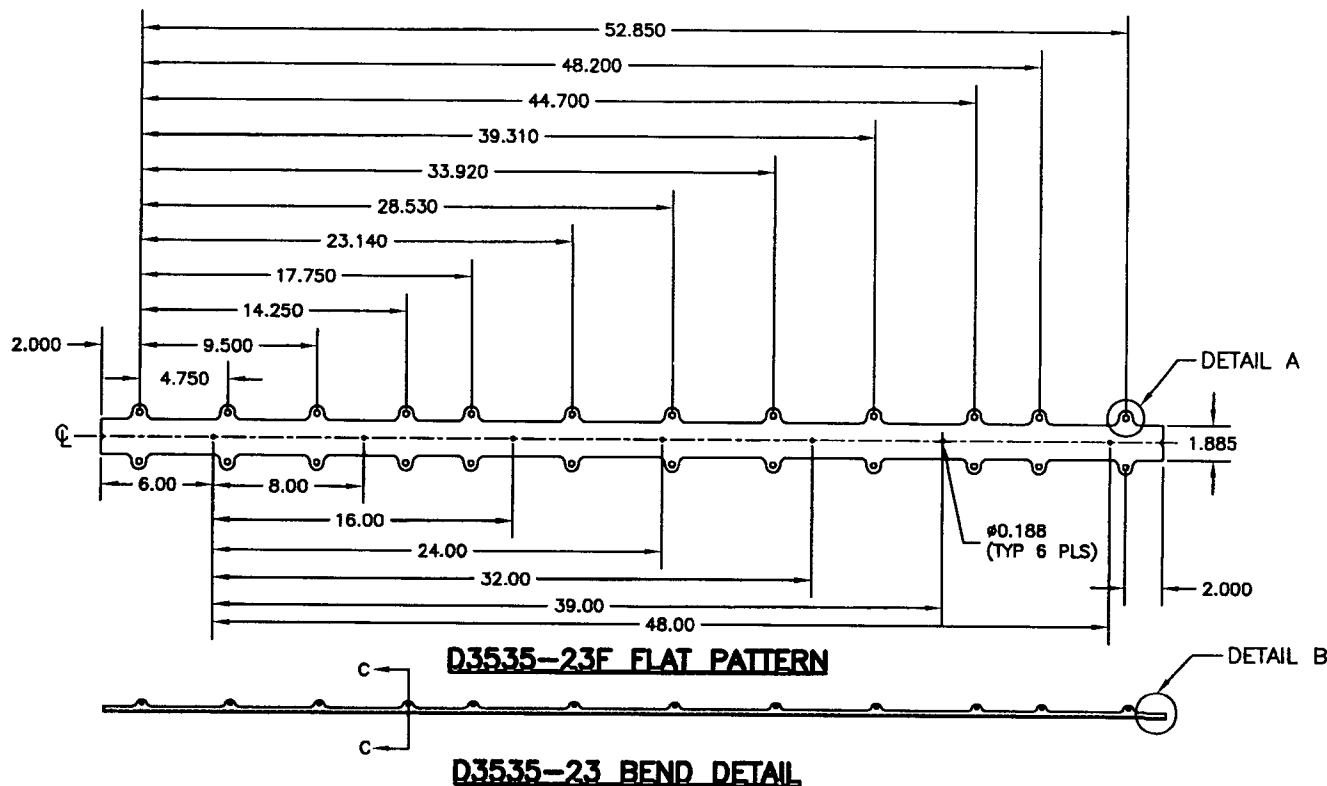
**NOTE:** Date & initial all entries

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CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 3 OF 7
	SCALE <b>1:10</b>	



**NOTES**

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W/O:		WORK ORDER CHANGES					
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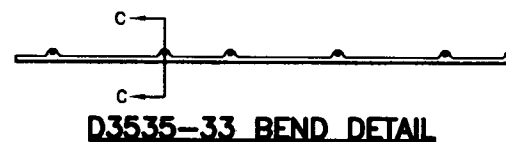
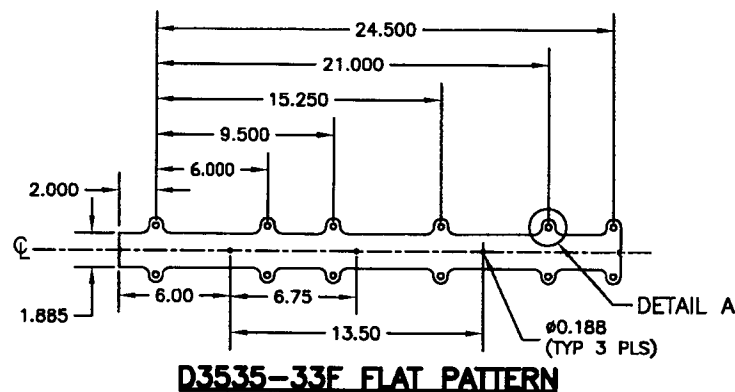
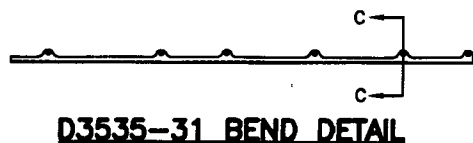
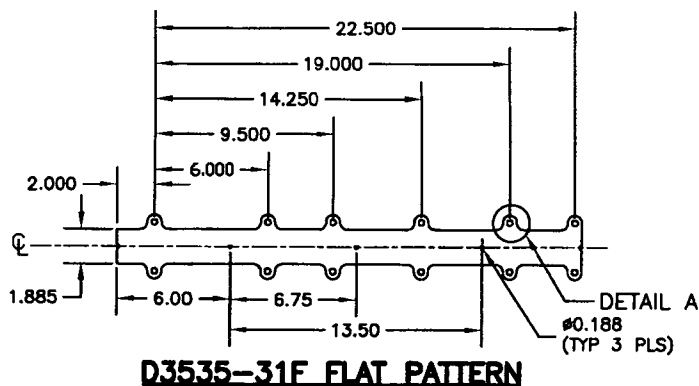
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07.04.24



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

W/O:		WORK ORDER CHANGES					
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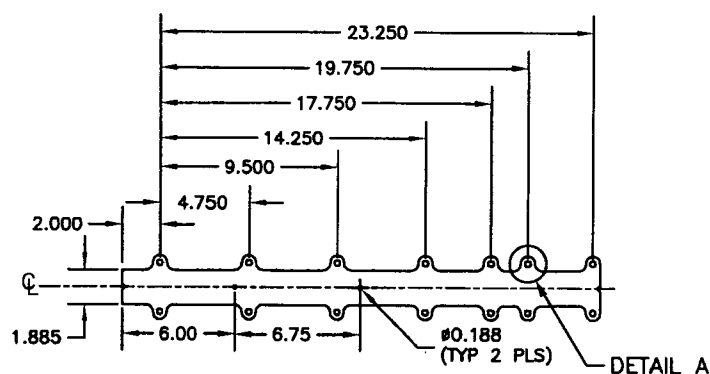
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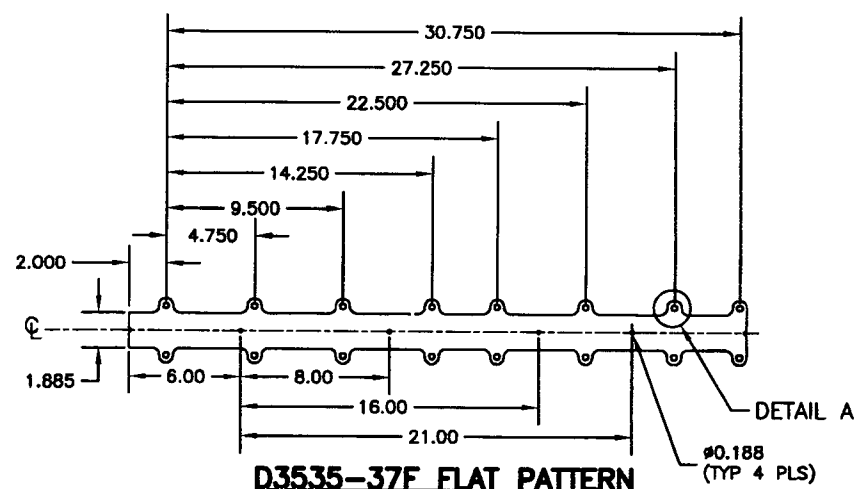
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07.04.17



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 5 OF 7
				SCALE 1:10

W/O:		WORK ORDER CHANGES					
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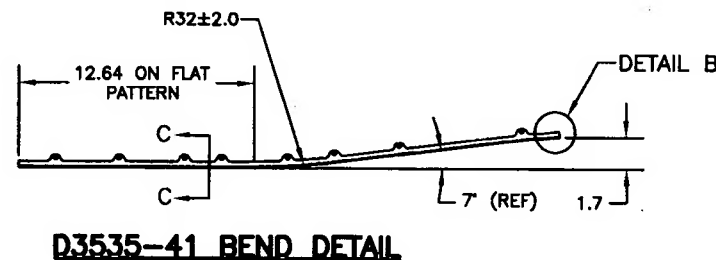
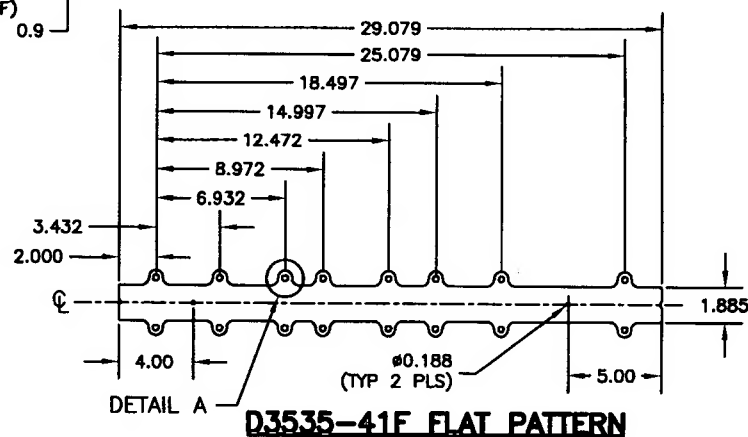
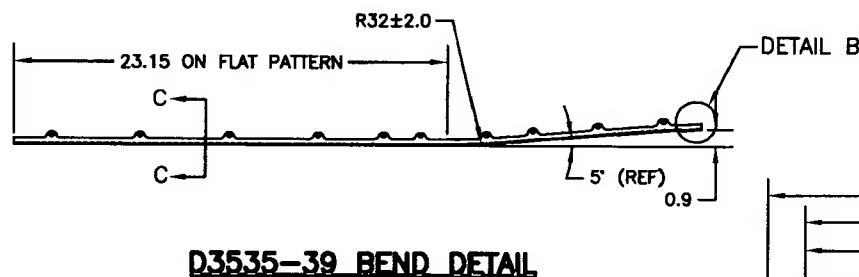
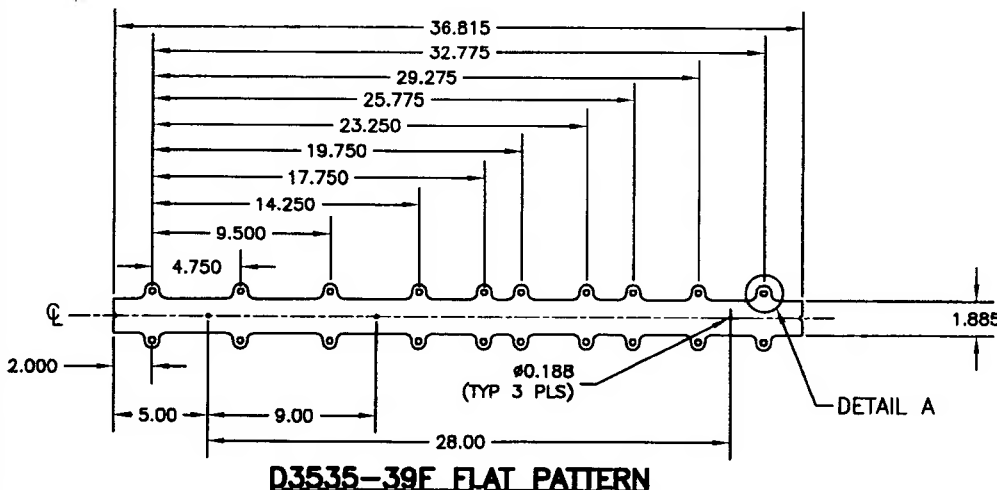
**NOTE:** Date & initial all entries

26230



RELEASED  
07.04.24

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED 	APPROVED 	DRAWING NO. <b>D3535</b>
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7
	SCALE 1:10	



**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

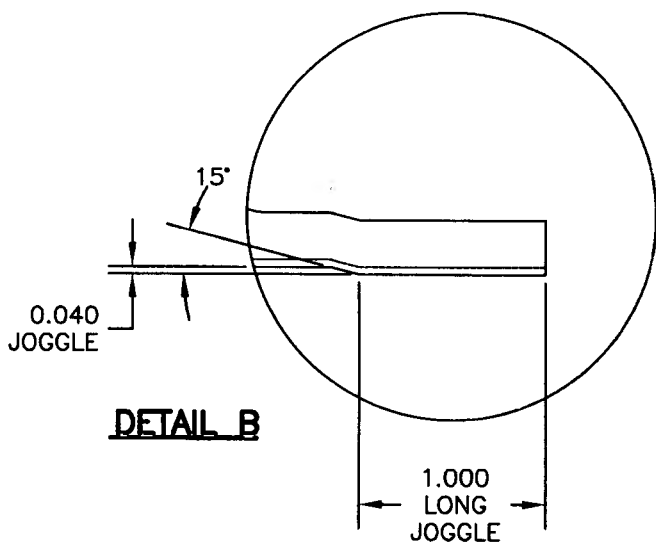
**NOTE:** Date & initial all entries

86230

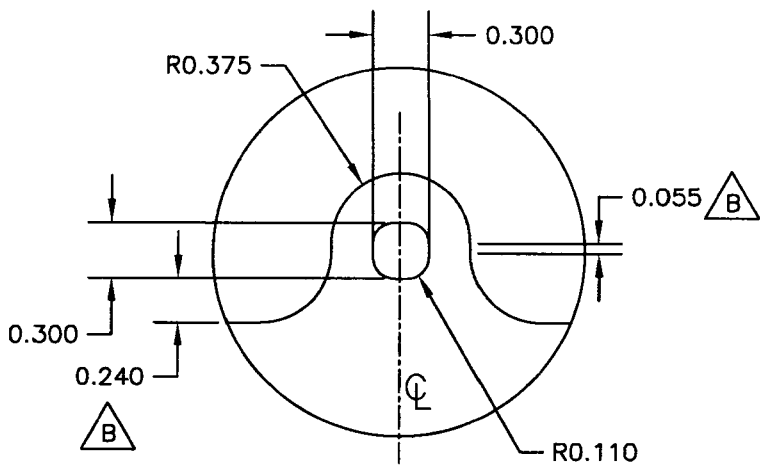


RELEASED  
07.01.24

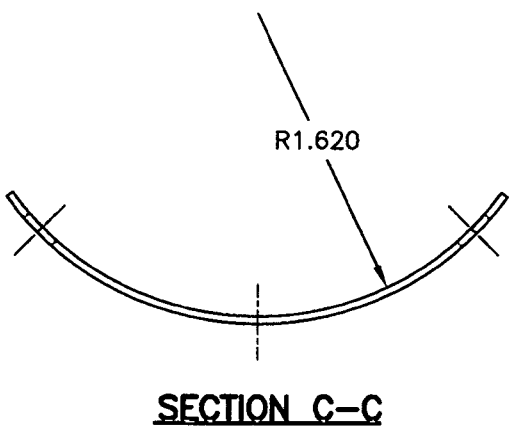
DESIGN	C B	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	



DETAIL B



DETAIL A



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries